

Work Order ID 69024



Page 1

Wednesday, April 27, 2011 10:56:48 AM

| | | | | | |
|--------------------------|------------------|--|---------------|-------|--|
| Item ID: D3910-3 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Crosstube Lug | | | | | |
| Start Date: 4/27/2011 | Start Qty: 20.00 | | Cust Item ID: | | |
| Required Date: 5/3/2011 | Req'd Qty: 20.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------|---------------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: 4/27/11 | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3910 | B | | | | | | | | |

| | | |
|----------------|------|--|
| 100 | 0.00 | |
| | | |
| Bandsaw | 0.00 | |
| Jeaspa Bandsaw | | |

Memo
Cut to 1.450" Long

cut extension @ meter

CL 11/04/28

| | | |
|------------------------------|------|--|
| 110 | 0.00 | |
| | | |
| HAAS 1 | 0.00 | |
| HAAS CNC vertical machine #1 | | |

Memo
MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV: _____
DWG REV: _____

DEBURR

issued P10 to meter

machine as per dwg D3910 REV. B

P10:13965

CL 11/04/28 (20)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 69024

Wednesday, April 27, 2011 10:56:48 AM

Page 2

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

Start Date: 4/27/2011 Start Qty: 20.00

Required Date: 5/3/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached c/c to W/O

130

QC
Quality Control

QC3- Inspect parts - second check

0.00

Memo

0.00

S 4/27/11

Counts
(420)

140

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

20X Ø M/L 4/25/11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69024

Wednesday, April 27, 2011 10:56:48 AM



Page 3

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

M116 964

Memo

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

START Time: 10:15
Oven Temp: 320 OF
Finish Time: 10:45

20 X 0 M-11/05/11

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

20 B 11-5-11

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

11/5/11 : SP 2.22

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Work Order ID 69024

Page 4

Wednesday, April 27, 2011 10:56:48 AM

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

11/5/11

0.00

11-05-11



QC

Memo

Quality Control

11/5/11

ME

11-05-11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 27, 2011 10:56:56 AM

Work Order ID: 69024



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-------|--|--------------|----|--|--|-----|---|----------|------|----------|--|--|--|
| D2423 | | Manufactured | No | | | 100 | f | 345.0300 | 0.13 | 2.736842 | | | |
|-------|--|--------------|----|--|--|-----|---|----------|------|----------|--|--|--|



Lug Extrusion



CZ11104/28

Location

Loc Qty

Loc Code

MAT006

345.03

43722 161.5

45800 1

63005 182.53

2.74

D 3910-3 P

x20

4/27/11 (20)

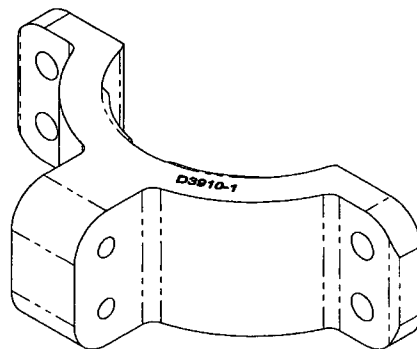
| W/O: | | WORK ORDER CHANGES | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

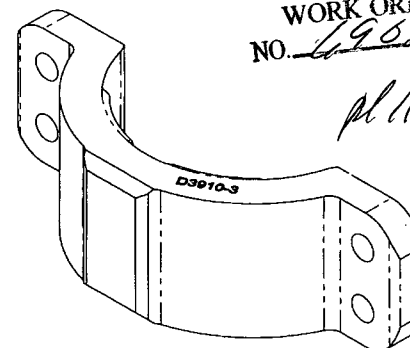
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69824

PL 11-09-27

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
2010-03-22
MD

| | | | | |
|------------|---|---|------------------|----------|
| B | Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2 | | JPH | 10.03.16 |
| A | NEW ISSUE | | JPH | 10.03.04 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | JPH | | | |
| CHECKED | | DRAWING NO. | D3910 | REV. B |
| MFG. APPR. | | SHEET 1 OF 3 | | |
| APPROVED | | TITLE | X-TUBE LUG (350) | SCALE |
| DE APPR. | | NTS | | |
| DATE | 10.03.16 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

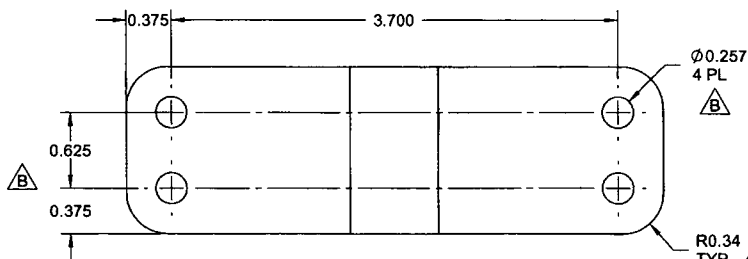
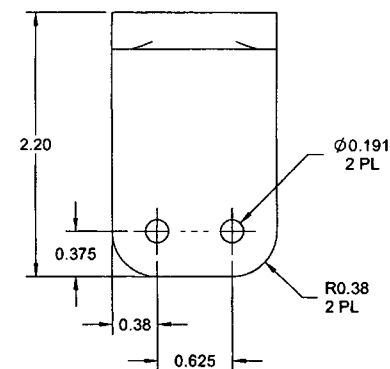
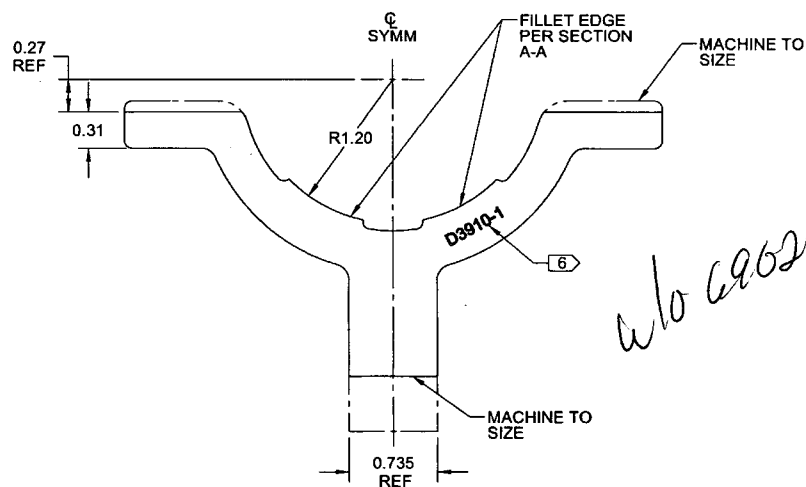
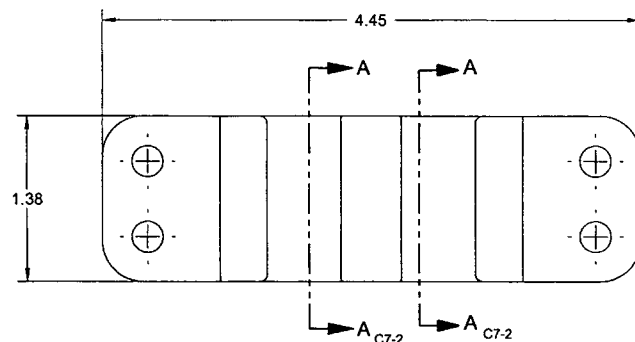
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries







ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

RELEASED
2010-03-22

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D3910 | SHEET 2 OF 3 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | X-TUBE LUG (350) | NTS |
| DATE | 10.03.16 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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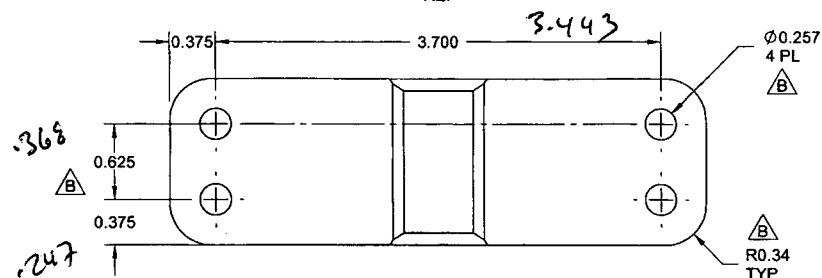
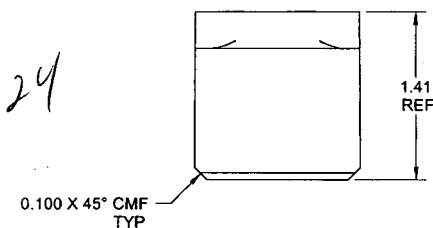
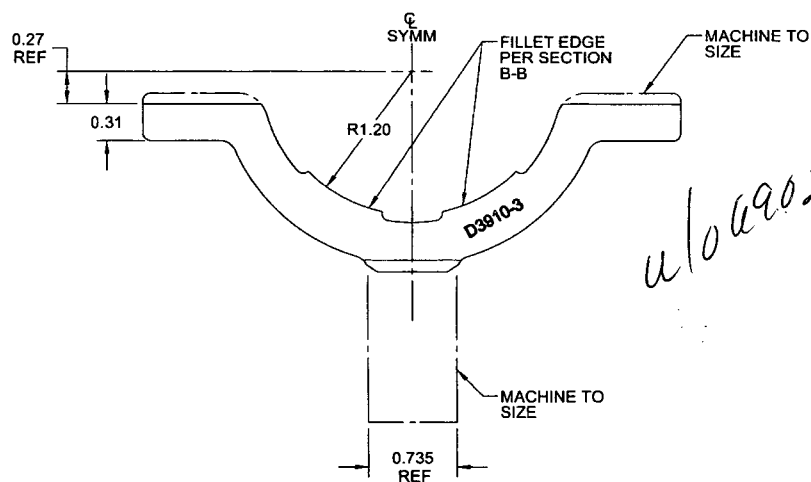
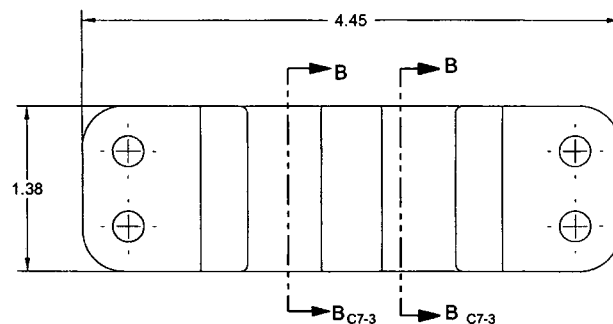
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| | | | | | | | | |

NOTE: Date & initial all entries






ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

| | | | |
|------------|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | | D3910 | SHEET 3 OF 3 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | X-TUBE LUG (350) | NTS |
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| | | | | | | | | |

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13965**

Purchase Order Date 4/28/2011

PO Print Date 4/28/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
4/11/12

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|----------------------|-----------------------------|-------------|------------|-------------------|
| 1 | D3910-3P | Crosstube Lug | 5/6/2011 Yes | 20.00 Each | Dart Truck | \$31.5500 | \$631.00 |

Special Inst:

MACHINE AS PER DWG D3910 REV. B
B69024

PO Total:

\$631.00

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 4/28/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17957
Date: May 10, 2011
Page: 1

| | |
|---|--|
| Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 | Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 |
| Order No.: 13965 | Sold By: Walz, Christian D. |
| Shipped By: your truck | Ship Date: |

| Description | Unit | Ordered quantity | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| 3910-3 Crosstube Lug Material supplied by DART: D2423 B63005 | Each | 20 | 20 | |
| The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted. | | | | |
| Received by _____ | | Thank you for your order! | | |



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

20

D3910-3

Crosstube Lug

13965

MATERIAL: supplied by DART D2423 B63005

8/11/14

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, May 10, 2011